

Work Order ID C77570*77570*

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December-13-11 1:52:51 PM

Item ID: D3591-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 13/12/2011 Start Qty: 40.00

40

Cust Item ID:

Required Date: 05/01/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: M.C.JDate: 11/12/13

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3591

Rev B

100

0.00

100

CONVENTIONAL LATHE

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn as per dwg D35912-Deburr

400SL 11/12/22

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

400SL 11/12/22

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

Re 11-12-22404

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 77570

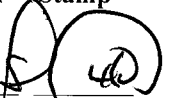
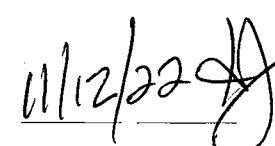
77570

Page 2

December-13-11 1:52:51 PM

Item ID: D3591-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bushing
 Start Date: 13/12/2011 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 05/01/2012 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>FPA</u> Memo	0.00 0.00							<u>11/12/22</u> 
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<u>11/12/22</u>  MF 11-12-22

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 77570

77570

Parent Item: D3591-1

D3591-1

Parent Item Name: Bushing

Start Date: 13/12/2011

Required Date: 05/01/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A 07.02.01 new issue EC
IPP Rev:B 08-09-10 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.035

Purchased

No

100

f

122.3053

0.35

14.73684

M304TR0 500W 0.35

16.167'

SI 11/12/22

304 RD Tube .500 x .035W

Location

Loc Qty

Loc Code

MAT017

122.3052723

115535

0.913

116720

1.66068

117598

7.6415923

119160

12.09

119644

100

16.167'

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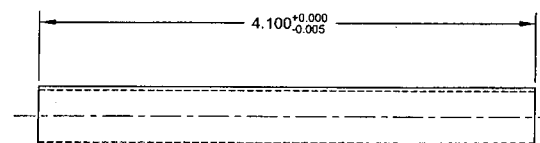
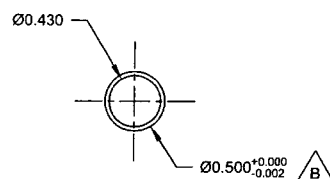
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NOTE: Date & initial all entries

SHOP
 RETU
 ENGIN
 UNCONTR
 SUBJECT T
 WITH
 WOI
 NO. 77570
 M.L.J
 11/12/13







D3591-1 BUSHING

RELEASED
 08/08/14

NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø0.500, 0.035 WALL SEAMLESS ROUND TUBING
 REF. DART SPEC M304TR0.500W.035
 OR: AISI 303/304/316 SS, ROUND BAR
 REF DART SPEC M303R/M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

B	DRAWING UPDATED TO "B" SIZE FORMAT AND CURRENT STANDARDS. ZN C6 TOLERANCE WAS -0.005. MATERIAL UPDATED TO ALLOW PART TO BE MACHINED TO MAINTAIN TOLERANCE. (SEE NCR 08-074 FOR FURTHER DETAILS.)		AJS	08.08.25
A	NEW ISSUE		PH	07.01.16
REV.	DESCRIPTION		BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV.	SHEET 1 OF 1
MFG. APPR.		D3591		
APPROVED		TITLE	SCALE	
DE APPR.		BUSHING	NT	
DATE	08.08.25	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

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